A low VOC, two component internally flexibilised high build surface tolerant epoxy primer. Pigmented with aluminium and lamellar micaceous iron oxide for improved corrosion resistance. This formulation represents second generation surface tolerant technology. The product has both application and performance characteristics optimised for use over a wider temperature range.

A high performance maintenance coating for use on a wide variety of surfaces including hand or power tool cleaned rusty steel. Ideal for use in conjunction with wet abrasive blasting or ultra high pressure water blasting, or as a patch primer for rusty surfaces in maintenance situations.

For use on hot surfaces continuously running at up to 150°C (302°F) and for corrosion protection under thermal insulation of carbon steel and stainless steel.

Colour | Aluminium
---|---
Gloss Level | Eggshell
Volume Solids | 80%
Typical Thickness | 75-150 microns (3-6 mils) dry equivalent to 94-188 microns (3.8-7.5 mils) wet
Theoretical Coverage | 6.40 m²/litre at 125 microns d.f.t and stated volume solids
Practical Coverage | 257 sq.ft/US gallon at 5 mils d.f.t and stated volume solids
Method of Application | Airless Spray, Air Spray, Brush, Roller

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Touch Dry</th>
<th>Hard Dry</th>
<th>Minimum</th>
<th>Maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>10°C (50°F)</td>
<td>12 hours</td>
<td>22 hours</td>
<td>22 hours</td>
<td>Extended¹</td>
</tr>
<tr>
<td>15°C (59°F)</td>
<td>9 hours</td>
<td>16 hours</td>
<td>16 hours</td>
<td>Extended¹</td>
</tr>
<tr>
<td>25°C (77°F)</td>
<td>5 hours</td>
<td>9 hours</td>
<td>9 hours</td>
<td>Extended¹</td>
</tr>
<tr>
<td>40°C (104°F)</td>
<td>2 hours</td>
<td>6 hours</td>
<td>6 hours</td>
<td>Extended¹</td>
</tr>
</tbody>
</table>

¹ See International Protective Coatings Definitions and Abbreviations
For curing at elevated temperatures an alternative curing agent is available. See Product Characteristics for details.

Ecotech is an initiative by International Protective Coatings a world leader in coating technology to promote the use of environmentally sensitive products across the globe.
The performance of this product will depend upon the degree of surface preparation. The surface to be coated must be clean and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be adequate for accumulated dirt. Soluble salts should be removed by fresh water washing.

**Abrasive Blast Cleaning**

Interplus 256 may be applied to a surface abrasive blast cleaned to a minimum Sa1 (ISO 8501-1:2007) C or D grade rusting, or SSPC SP7.

**Hand or Power Tool Preparation**

Hand or power tool clean to a minimum of Si2 (ISO 8501-1:2007) or SSPC-SP2.

Note, all scale must be removed and areas which cannot be prepared adequately by chipping or needle gun should be spot blasted to a minimum standard of Sa2 (ISO 8501-1:2007) or SSPC-SP6. Typically this would apply to C or D grade rusting in this standard.

On hot steel surfaces, cleaning to a minimum St3 (ISO 8501-1:2007) or SSPC SP3 is required. Optimum performance will be achieved from SSPC-SP11 for hand preparation, or blasting to Sa2 (ISO 8501-1:2007) or SSPC-SP6.

**Ultra High Pressure Hydroblasting / Abrasive Wet Blasting**

May be applied to surfaces prepared to Sa2 (ISO 8501-1:2007) or SSPC-SP6 which have flash rusted to no worse than Grade HB2½M (refer to International Hydroblasting Standards). It is also possible to apply to damp surfaces in some circumstances. Further information is available from International Protective Coatings.

**Aged Coatings**

Interplus 256 is suitable for overlap onto most aged coating systems. Loose or flaking coatings should be removed back to a firm edge. Glossy epoxies and polyurethanes may require abrasion.

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### Mix Ratio

3.0 part(s) : 1.0 part(s) by volume

### Working Pot Life

<table>
<thead>
<tr>
<th>Temperature</th>
<th>10°C (50°F)</th>
<th>15°C (59°F)</th>
<th>25°C (77°F)</th>
<th>40°C (104°F)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Time</td>
<td>2 hours</td>
<td>90 minutes</td>
<td>60 minutes</td>
<td>30 minutes</td>
</tr>
</tbody>
</table>

For curing at elevated temperatures an alternative curing agent is available. See Product Characteristics for details.

### Airless Spray

**Suitable**

- Tip Range: 0.45-0.58 mm (18-23 thou)
- Total output fluid pressure at spray tip not less than 176 kg/cm² (2503 p.s.i.)

### Air Spray (Pressure Pot)

**Suitable**

- Gun: DeVilbiss MBC or JGA
- Air Cap: 704 or 765
- Fluid Tip: E

**Recommended**

- Typically 75-125 microns (3.0-5.0 mils) can be achieved

### Roller

**Recommended**

- Typically 75-100 microns (3.0-4.0 mils) can be achieved

### Thinner

- International GTA220
- Do not thin

### Cleaner

- International GTA822 or International GTA415

### Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.

### Clean Up

Clean all equipment immediately after use with International GTA822. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays.

All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.
Interplus 256 is the preferred product for application to hand prepared rusty steel, and is particularly suitable as a patch primer. In these circumstances, application should be performed by brush to ensure good wetting of the hand prepared substrate. For larger areas which have been prepared by power tool cleaning, or brush blast, other products may be suitable. Please consult International Protective Coatings for details.

In order to ensure good anti-corrosive performance, it is important to achieve a minimum system dry film thickness of 200 microns (8 mils) by application of multi-coats over hand prepared steel.

When applying Interplus 256 by brush, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

To ensure good aged overcoating of Interplus 256 by other materials the surface must be clean, dry and free from contamination, particularly if the surface profile is rough due to the presence of micaceous iron oxide.

Application and curing at temperatures below 10°C (50°F) will result in significantly prolonged curing times, and in these circumstances it is recommended that Interplus 356 should be used.

Interplus 256 can be applied to substrates with surface temperatures at time of application up to 100°C (212°F). In these circumstances, rapid application of multiple coats is necessary to achieve the correct film thickness, and suitable personal protection equipment is essential during application due to the rapid release of volatiles from the applied film. Refer to Interplus 256 Recommended Working Procedures.

Interplus 256 is suitable for protection of steel operating at continuous dry temperatures of up to 150°C (302°F), with intermittent surges up to 200°C (392°F).

Interplus 256 is not designed for continuous water immersion.

**Elevated Temperature Curing**

An alternative curing agent is available for applications at temperatures greater than 25°C (77°F).

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Touch Dry</th>
<th>Hard Dry</th>
<th>Minimum</th>
<th>Maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>25°C (77°F)</td>
<td>6 hours</td>
<td>11 hours</td>
<td>11 hours</td>
<td>Extended*</td>
</tr>
<tr>
<td>40°C (104°F)</td>
<td>3 hours</td>
<td>7 hours</td>
<td>7 hours</td>
<td>Extended*</td>
</tr>
</tbody>
</table>

* See International Protective Coatings Definitions & Abbreviations

Working pot life time at 25°C (77°F) is 1½ hours, and at 40°C (104°F) is 1 hour

Note: VOC values quoted are based on maximum possible for the product taking into account variations due to colour differences and normal manufacturing tolerances.

**SYSTEMS COMPATIBILITY**

Interplus 256 will generally be applied to bare steel but is fully compatible for overlap onto most aged coatings, in addition to touch up repair of the following primers:

- Intercure 200
- Intergard 251
- Intergard 269
- Intergard 280
- Interseal 670HS
- Interfine 629HS
- Intergard 475HS
- Intergard 740
- Interplus 256
- Interplus 770
- Intergard 52
- Intergard 12
- Intergard 22
- Intergard 42
- Intergard 52
- Interseal 670HS
- Interseal 670HS
- Interthane 990
- Interzone 505
- Interzone 954
- Interplus 880
- Interplus 880

Recommended topcoats/intermediates are:

- Intercure 420
- Interfine 629HS
- Intergard 475HS
- Intergard 740
- Interplus 256
- Interplus 770

It should be noted that Interplus 256 is not suitable for overcoating with thin films of alkyd, chlorinated rubber, vinyl or acrylic finishes.

For other suitable topcoats/intermediates consult International Protective Coatings.
Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which International Protective Coatings has provided to its customers.

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult International Protective Coatings for further advice.

### PACK SIZE

<table>
<thead>
<tr>
<th>Unit Size</th>
<th>Part A</th>
<th>Part B</th>
</tr>
</thead>
<tbody>
<tr>
<td>5 litre</td>
<td>3.75 litre</td>
<td>1.25 litre</td>
</tr>
<tr>
<td>4 US gal</td>
<td>3 US gal</td>
<td>1 US gal</td>
</tr>
</tbody>
</table>

For availability of other pack sizes, contact International Protective Coatings.

### SHIPPING WEIGHT

<table>
<thead>
<tr>
<th>Unit Size</th>
<th>Part A</th>
<th>Part B</th>
</tr>
</thead>
<tbody>
<tr>
<td>5 litre</td>
<td>6.2 kg</td>
<td>1.73 kg</td>
</tr>
<tr>
<td>4 US gal</td>
<td>41.4 lb</td>
<td>9.2 lb</td>
</tr>
</tbody>
</table>

U.N. Shipping No. UN 1263 (Part A) : UN 1760 (Part B)

### STORAGE

| Shelf Life | 12 months (Part A) & 24 months (Part B) minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition. |